

Work Order ID 100441

April-22-13 7:40:29 PM

\*100441\*

Page 1

Item ID: D3916-5

Accept

\*N900040100\*

Setup

Start

\*NS1\*

Revision ID:

Item Name: Light Rib

Stop

\*NS2\*

Start Date: 5/06/13 Start Qty: 12.00 \*12\*

Cust Item ID:

Required Date: 5/06/13 Req'd Qty: 12.00 \*12\*

Customer:

Reference:

Approvals:

Process Plan: MUS

Date: 13-04-12 Tooling:

Date:

Run

Start

\*NR1\*

QC:

Date: SPC (Y/N):

Date:

Stop

\*NR2\*

| Sequence ID/<br>Work Center ID | Operation<br>Description | Set Up/<br>Run Hours | Tool ID | Tool # | Plan<br>Code | Accept<br>Qty | Reject<br>Qty | Reject<br>Number | Insp.<br>Stamp |
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|

| Draw Nbr | Revision Nbr |
|----------|--------------|
|----------|--------------|

|       |   |
|-------|---|
| D3916 | A |
|-------|---|

100

\*100\*

Large Fab

Large Fab

Memo  
1-Cut tube 50"  
2-Bend tube with manuel pipe bender as per DT9566  
\*\*\* Make line at 9.00" and use jig for other line\*\*\*  
3-Trim access tube material to finish size as per dwg D3916

110

\*110\*

QC

Quality Control

QC6- Inspect dimensions to drawing 0.00

Memo 0.00

120

\*120\*

Packaging

Packaging

Identify as per dwg & Stock Location: 0.00

Memo 0.00

(12) 37L 13-08-14

DAS

09

0.00

(12) B-08-15

DAS

09

0.00

(12) - B-08-15

DAS

09

0.00

NCR: Yes / No

## **WORK ORDER NON-CONFORMANCE / UPDATE**

DQA: Date:

QA Closed: Date:

| Work Order: _____                           |   |   |  | DISPOSITION   |   | AGAINST DEPARTMENT/PROCESS         |  |                                      |              |  |  |
|---|---|---|--|---|---|------------------------------------|--|--------------------------------------|--------------|--|--|
|   |   |   |  | Rework <input type="checkbox"/>                     | Skid-tube <input type="checkbox"/>          | Crosstube <input type="checkbox"/> | Water Jet <input type="checkbox"/>           | Engineering <input type="checkbox"/> |              |  |  |
|   |   |   |  | Scrap <input type="checkbox"/>                      | Machining <input type="checkbox"/>          | Small Fab <input type="checkbox"/> | Prod. Eng. Coor. <input type="checkbox"/>    | Quality <input type="checkbox"/>     |              |  |  |
|   |   |   |  | Use-as-is <input type="checkbox"/>                  | Thermoforming <input type="checkbox"/>      | Finishing <input type="checkbox"/> | Rec/Store/Packaging <input type="checkbox"/> | Other <input type="checkbox"/>       |              |  |  |
|   |   |   |  | Work Order Update <input type="checkbox"/>          | Large Fab <input type="checkbox"/>          | Composite <input type="checkbox"/> | Supplier <input type="checkbox"/>            |                                      |              |  |  |
| Root Cause                                  | Date  | Step  | Qty  | Description of work order update or Non-conformance | Initial Chief Eng                           | Action Description                 | Sign & Date                                  | Verification                         | QC Inspector |  |  |
| Doc/Data                                    |   |   |  |   |   |                                    |  |                                      |              |  |  |
| Equip/Tooling                               |   |   |  |   |   |                                    |  |                                      |              |  |  |
| Operator                                    |   |   |  |   |   |                                    |  |                                      |              |  |  |
| Material                                    |   |   |  |   |   |                                    |  |                                      |              |  |  |
| Setup                                       |   |   |  |   |   |                                    |  |                                      |              |  |  |
| Other                                       |   |   |  |   |   |                                    |  |                                      |              |  |  |
| Process                                     |   |   |  |   |   |                                    |  |                                      |              |  |  |
| Supplier                                    |   |   |  |   |   |                                    |  |                                      |              |  |  |
| Training                                    |   |   |  |   |   |                                    |  |                                      |              |  |  |
| Unapproved                                  |   |   |  |   |   |                                    |  |                                      |              |  |  |
| FAULT CATEGORY                              |   |   |  |   |   |                                    |  |                                      |              |  |  |
| Landing Gear                                |   |   |  | General   |   |                                    |  |                                      |              |  |  |
| CO  | Bending <input type="checkbox"/>                      | Bend <input type="checkbox"/>               | Grain <input type="checkbox"/>                           | Ovalized <input type="checkbox"/>                   | Pressure/Forced <input type="checkbox"/>    |                                    |  |                                      |              |  |  |
|   | Centre Not Concentric to O/S <input type="checkbox"/> | BOM/Route <input type="checkbox"/>          | Hardware <input type="checkbox"/>                        | Over/Under tolerance <input type="checkbox"/>       | Temperature/Cure <input type="checkbox"/>   |                                    |  |                                      |              |  |  |
|   | Cracks <input type="checkbox"/>                       | Broken/Damaged <input type="checkbox"/>     | Inspection Incomplete <input type="checkbox"/>           | Part Incorrect <input type="checkbox"/>             | Weld <input type="checkbox"/>               |                                    |  |                                      |              |  |  |
|   | Crushed/Crimped <input type="checkbox"/>              | Burrs <input type="checkbox"/>              | Instructions Incomplete/Unclear <input type="checkbox"/> | Part Lost/Missing <input type="checkbox"/>          | Wrong Stock Pulled <input type="checkbox"/> |                                    |  |                                      |              |  |  |
|   | Cuffs <input type="checkbox"/>                        | Contamination <input type="checkbox"/>      | Maintenance <input type="checkbox"/>                     | Part Moved <input type="checkbox"/>                 |   |                                    |  |                                      |              |  |  |
|   | Heat Treat <input type="checkbox"/>                   | Countersink <input type="checkbox"/>        | Mislabeled <input type="checkbox"/>                      | Positioned Wrong <input type="checkbox"/>           |   |                                    |  |                                      |              |  |  |
|   | Inspection Strip in Tube <input type="checkbox"/>     | Cut Too Short <input type="checkbox"/>      | Misread <input type="checkbox"/>                         | Power Loss/Surge <input type="checkbox"/>           |   |                                    |  |                                      |              |  |  |
|   | Ripples in Bend <input type="checkbox"/>              | Drill Holes <input type="checkbox"/>        | Offset <input type="checkbox"/>                          |   |   |                                    |  |                                      |              |  |  |
|   | Torque Waves in Extrusion <input type="checkbox"/>    | Drawing <input type="checkbox"/>            | Out of Calibration <input type="checkbox"/>              |   |   |                                    |  |                                      |              |  |  |
|   | Turning Sequence <input type="checkbox"/>             | Finish <input type="checkbox"/>             | Out of Sequence <input type="checkbox"/>                 |   |   |                                    |  |                                      |              |  |  |
| Wave/Twist in Tube <input type="checkbox"/> | Folio <input type="checkbox"/>                        | Outside Dimensions <input type="checkbox"/> |  |   |   |                                    |  |                                      |              |  |  |



NCR: Yes / No

DQA: Date:

## **WORK ORDER NON-CONFORMANCE / UPDATE**

QA Closed: Date:

| Work Order: _____            |      |                |     | DISPOSITION   |  | AGAINST DEPARTMENT/PROCESS   |  |   |              |  |  |
|------------------------------|------|----------------|-----|---|--|--|--|---|--------------|--|--|
|                              |      |                |     | Rework<br><input type="checkbox"/><br>Scrap<br><input type="checkbox"/><br>Use-as-is<br><input type="checkbox"/><br>Work Order Update<br><input type="checkbox"/> | Skid-tube<br><input type="checkbox"/><br>Machining<br><input type="checkbox"/><br>Thermoforming<br><input type="checkbox"/><br>Large Fab<br><input type="checkbox"/> | Crosstube<br><input type="checkbox"/><br>Small Fab<br><input type="checkbox"/><br>Finishing<br><input type="checkbox"/><br>Composite<br><input type="checkbox"/> | Water Jet<br><input type="checkbox"/><br>Prod. Eng. Coor.<br><input type="checkbox"/><br>Rec/Store/Packaging<br><input type="checkbox"/><br>Supplier<br><input type="checkbox"/> | Engineering<br><input type="checkbox"/><br>Quality<br><input type="checkbox"/><br>Other<br><input type="checkbox"/> |              |  |  |
| Part No. _____               |      |                |     |   |  |  |  |   |              |  |  |
| NCR No. _____                |      |                |     |   |  |  |  |   |              |  |  |
| Root Cause                   | Date | Step           | Qty | Description of work order update or Non-conformance   | Initial Chief Eng  | Action Description   | Sign & Date  | Verification  | QC Inspector |  |  |
| Doc/Data                     |      |                |     |   |  |  |  |   |              |  |  |
| Equip/Tooling                |      |                |     |   |  |  |  |   |              |  |  |
| Operator                     |      |                |     |   |  |  |  |   |              |  |  |
| Material                     |      |                |     |   |  |  |  |   |              |  |  |
| Setup                        |      |                |     |   |  |  |  |   |              |  |  |
| Other                        |      |                |     |   |  |  |  |   |              |  |  |
| Process                      |      |                |     |   |  |  |  |   |              |  |  |
| Supplier                     |      |                |     |   |  |  |  |   |              |  |  |
| Training                     |      |                |     |   |  |  |  |   |              |  |  |
| Unapproved                   |      |                |     |   |  |  |  |   |              |  |  |
| FAULT CATEGORY               |      |                |     |   |  |  |  |   |              |  |  |
| Landing Gear                 |      |                |     | General   |  |  |  |   |              |  |  |
| Bending                      |      | Bend           |     | Grain   |  | Ovalized   |  | Pressure/Forced   |              |  |  |
| Centre Not Concentric to O/S |      | BOM/Route      |     | Hardware  |  | Over/Under tolerance   |  | Temperature/Cure  |              |  |  |
| Cracks                       |      | Broken/Damaged |     | Inspection Incomplete   |  | Part Incorrect   |  | Weld  |              |  |  |
| Crushed/Crimped              |      | Burrs          |     | Instructions Incomplete/Unclear   |  | Part Lost/Missing  |  | Wrong Stock Pulled  |              |  |  |
| Cuffs                        |      | Contamination  |     | Maintenance   |  | Part Moved   |  |   |              |  |  |
| Heat Treat                   |      | Countersink    |     | Mislabeled  |  | Positioned Wrong   |  |   |              |  |  |
| Inspection Strip in Tube     |      | Cut Too Short  |     | Misread   |  | Power Loss/Surge   |  |   |              |  |  |
| Ripples in Bend              |      | Drill Holes    |     | Offset  |  |  |  |   |              |  |  |
| Torque Waves in Extrusion    |      | Drawing        |     | Out of Calibration  |  |  |  |   |              |  |  |
| Turning Sequence             |      | Finish         |     | Out of Sequence   |  |  |  |   |              |  |  |
| Wave/Twist in Tube           |      | Folio          |     | Outside Dimensions  |  |  |  |   |              |  |  |

# Picklist Print

April-22-13 1:40:29 PM

Page 1

Work Order ID: 100441

Parent Item: D3916-5

Parent Item Name: Light Rib

Start Date: 5/06/13

Required Date: 5/06/13

Start Qty: 12.00

Required Qty: 12.00

Comments: IPP RevA: new issue DD 09.11.23 verified by:EC  
10.03.15 verified by:EC

IPP RevB: as per dwg revA

| Component Item ID/<br>Item Name   | Replacement<br>Item ID | Mfg/<br>Purch | Bin<br>Item | Primary<br>Location | Last<br>Location | Route<br>Seq ID | Unit of<br>Measure | Qty on<br>Hand | Qty per Kit | Total<br>Qty | Qty<br>Issued | Date<br>Issued       | Status |
|-----------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|-------------|--------------|---------------|----------------------|--------|
| M304TS0.500W.049<br>Square Tubing |                        | Purchased     | No          |                     |                  | 100             | f                  | 1,065.9843     | 4.166       | 52.623158    | <u>52</u>     | <u>22</u> - 13-08-14 |        |

| Location | Loc Qty     | Loc Code |
|----------|-------------|----------|
| WA006    | 1065.984331 |          |
| 118460   | 0.00001534  |          |
| 122938   | 224.3       |          |
| 123565   | 198.684316  |          |
| 125062   | 643         |          |

m 126 080

NCR: Yes / No

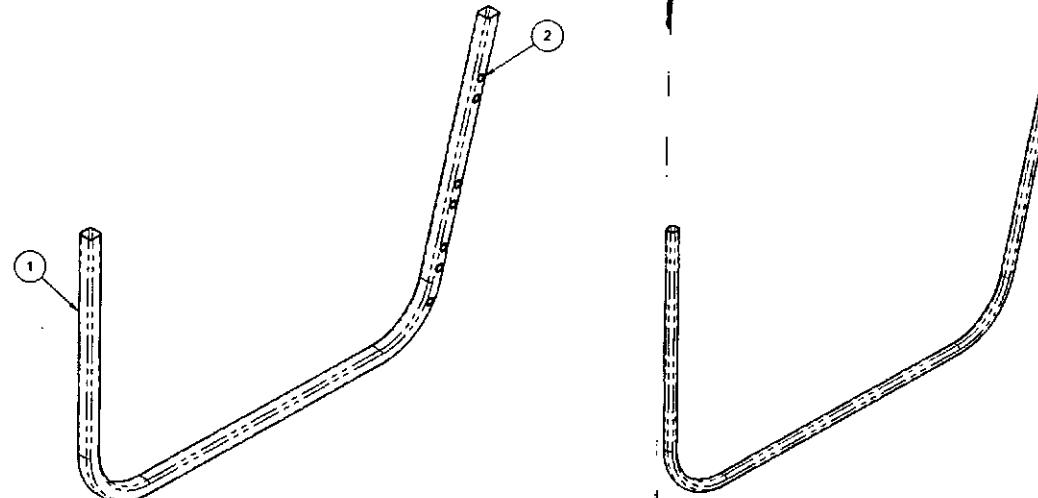
DQA: \_\_\_\_\_ Date: \_\_\_\_\_

**WORK ORDER NON-CONFORMANCE / UPDATE**

QA Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| Work Order: _____                                     |  |  | DISPOSITION                                   |   | AGAINST DEPARTMENT/PROCESS         |                                      |             |              |              |  |
|---|--|--|---|---|------------------------------------|--------------------------------------|-------------|--------------|--------------|--|
| Part No. _____  | Rework <input type="checkbox"/>            | Scrap <input type="checkbox"/>                           | Skid-tube <input type="checkbox"/>            | Crosstube <input type="checkbox"/>                  | Water Jet <input type="checkbox"/> | Engineering <input type="checkbox"/> |             |              |              |  |
| NCR No. _____   | Use-as-is <input type="checkbox"/>         | Thermoforming <input type="checkbox"/>                   | Small Fab <input type="checkbox"/>            | Prod. Eng. Coor. <input type="checkbox"/>           | Quality <input type="checkbox"/>   |                                      |             |              |              |  |
|   | Work Order Update <input type="checkbox"/> | Large Fab <input type="checkbox"/>                       | Finishing <input type="checkbox"/>            | Rec/Store/Packaging <input type="checkbox"/>        | Other <input type="checkbox"/>     |                                      |             |              |              |  |
| Root Cause  | Date                                       | Step   | Qty   | Description of work order update or Non-conformance | Initial Chief Eng                  | Action Description                   | Sign & Date | Verification | QC Inspector |  |
| Doc/Data  |  |  |   |   |                                    |                                      |             |              |              |  |
| Equip/Tooling   |  |  |   |   |                                    |                                      |             |              |              |  |
| Operator  |  |  |   |   |                                    |                                      |             |              |              |  |
| Material  |  |  |   |   |                                    |                                      |             |              |              |  |
| Setup   |  |  |   |   |                                    |                                      |             |              |              |  |
| Other   |  |  |   |   |                                    |                                      |             |              |              |  |
| Process   |  |  |   |   |                                    |                                      |             |              |              |  |
| Supplier  |  |  |   |   |                                    |                                      |             |              |              |  |
| Training  |  |  |   |   |                                    |                                      |             |              |              |  |
| Unapproved  |  |  |   |   |                                    |                                      |             |              |              |  |
| FAULT CATEGORY  |  |  |   |   |                                    |                                      |             |              |              |  |
| Landing Gear  |  |  | General                                       |   |                                    |                                      |             |              |              |  |
| Bending <input type="checkbox"/>                      | Bend <input type="checkbox"/>              | Grain <input type="checkbox"/>                           | Ovalized <input type="checkbox"/>             | Pressure/Forced <input type="checkbox"/>            |                                    |                                      |             |              |              |  |
| Centre Not Concentric to O/S <input type="checkbox"/> | BOM/Route <input type="checkbox"/>         | Hardware <input type="checkbox"/>                        | Over/Under tolerance <input type="checkbox"/> | Temperature/Cure <input type="checkbox"/>           |                                    |                                      |             |              |              |  |
| Cracks <input type="checkbox"/>                       | Broken/Damaged <input type="checkbox"/>    | Inspection Incomplete <input type="checkbox"/>           | Part Incorrect <input type="checkbox"/>       | Weld <input type="checkbox"/>                       |                                    |                                      |             |              |              |  |
| Crushed/Crimped <input type="checkbox"/>              | Burrs <input type="checkbox"/>             | Instructions Incomplete/Unclear <input type="checkbox"/> | Part Lost/Missing <input type="checkbox"/>    | Wrong Stock Pulled <input type="checkbox"/>         |                                    |                                      |             |              |              |  |
| Cuffs <input type="checkbox"/>                        | Contamination <input type="checkbox"/>     | Maintenance <input type="checkbox"/>                     | Part Moved <input type="checkbox"/>           |   |                                    |                                      |             |              |              |  |
| Heat Treat <input type="checkbox"/>                   | Countersink <input type="checkbox"/>       | Mislabeled <input type="checkbox"/>                      | Positioned Wrong <input type="checkbox"/>     |   |                                    |                                      |             |              |              |  |
| Inspection Strip in Tube <input type="checkbox"/>     | Cut Too Short <input type="checkbox"/>     | Misread <input type="checkbox"/>                         | Power Loss/Surge <input type="checkbox"/>     |   |                                    |                                      |             |              |              |  |
| Ripples in Bend <input type="checkbox"/>              | Drill Holes <input type="checkbox"/>       | Offset <input type="checkbox"/>                          |   | Other <input type="checkbox"/>                      |                                    |                                      |             |              |              |  |
| Torque Waves in Extrusion <input type="checkbox"/>    | Drawing <input type="checkbox"/>           | Out of Calibration <input type="checkbox"/>              |   |   |                                    |                                      |             |              |              |  |
| Turning Sequence <input type="checkbox"/>             | Finish <input type="checkbox"/>            | Out of Sequence <input type="checkbox"/>                 |   |   |                                    |                                      |             |              |              |  |
| Wave/Twist in Tube <input type="checkbox"/>           | Folio <input type="checkbox"/>             | Outside Dimensions <input type="checkbox"/>              |   |   |                                    |                                      |             |              |              |  |

| ITEM | QTY | P/N       | DESCRIPTION |
|------|-----|-----------|-------------|
|      | X   | D3916-041 | RIB ASSY    |
| 1    | 1   | D3916-1   | RIB         |
| 2    | 7   | D3759-1   | BUSHING     |



D3916-041 RIB ASSY

D3916-5 LIGHT RIB

100441 MCS

13-04-22

06/10.12.21

**UNDER REVIEW**  
A 10.10  
ADDITION OF HOLE & DRAWINGS  
ON D3916-041 RIBS.

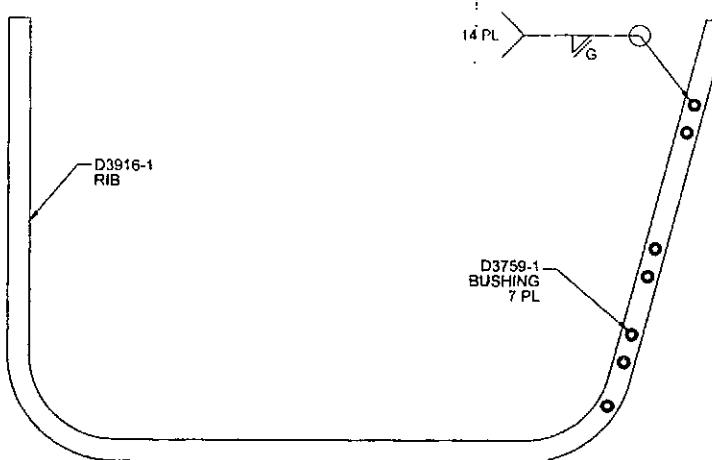
**RELEASED**  
2010-03-12  
MP

| A          | NEW ISSUE | JPH                         | 10.03.04     |
|------------|-----------|-----------------------------|--------------|
| REV.       | BY        | DATE                        |              |
| DESIGN     | AJS       | DESCRIPTION                 |              |
| DRAWN      | JPH       | DART AEROSPACE LTD          |              |
| CHECKED    |           | HAWKESBURY, ONTARIO, CANADA |              |
| MFG. APPR. |           | DRAWING NO.                 | REV. A       |
| APPROVED   |           | D3916                       | SHEET 1 OF 4 |
| DE APPR.   |           | TITLE                       | SCALE        |
| DATE       | 10.03.04  | RIB ASSY, 360 BASKET        | NTS          |

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100441

D3916-041 RIB ASSY

**RELEASED**  
2010-03-12  
*RP*

NOTES:  
 1) MATERIAL: N/A  
 2) FINISH: NONE  
 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED  
 4) UNITS: INCHES UNLESS OTHERWISE NOTED  
 5) BREAK SHARP EDGES: N/A  
 6) IDENTIFICATION: NONE  
 7) WEIGHT -041: 1.84 lbs  
 8) WELD PER DART QSI 004

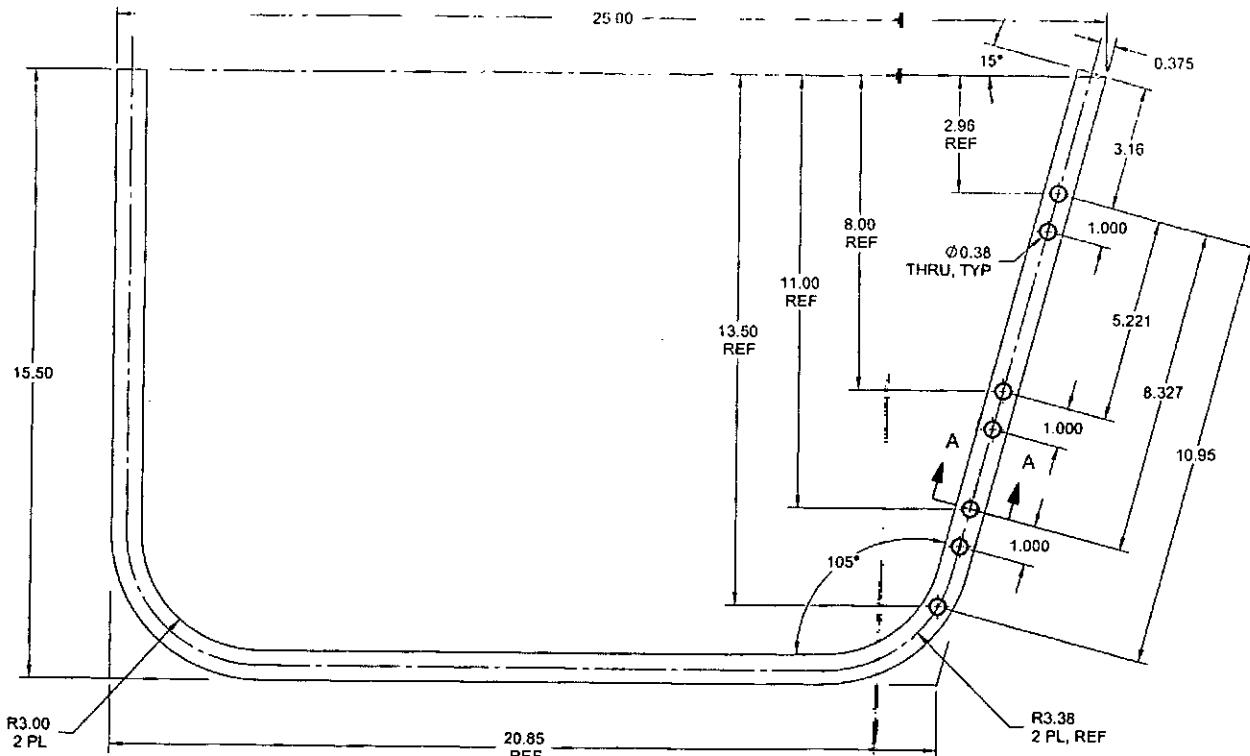
8 7 6 5 4 3 2 1 0

|            |           |                             |
|------------|-----------|-----------------------------|
| DESIGN     | AJS       | <b>DART AEROSPACE LTD</b>   |
| DRAWN      | JPH       | HAWKESBURY, ONTARIO, CANADA |
| CHECKED    | <i>GP</i> | DRAWING NO. REV. A          |
| MFG. APPR. | <i>EZ</i> | D3916 SHEET 2 OF 4          |
| APPROVED   | <i>NV</i> | TITLE                       |
| DE APPR.   | <i>AV</i> | SCALE                       |
| DATE       | 10.03.04  | NTS                         |

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100441



⑨ D3916-1 RIB

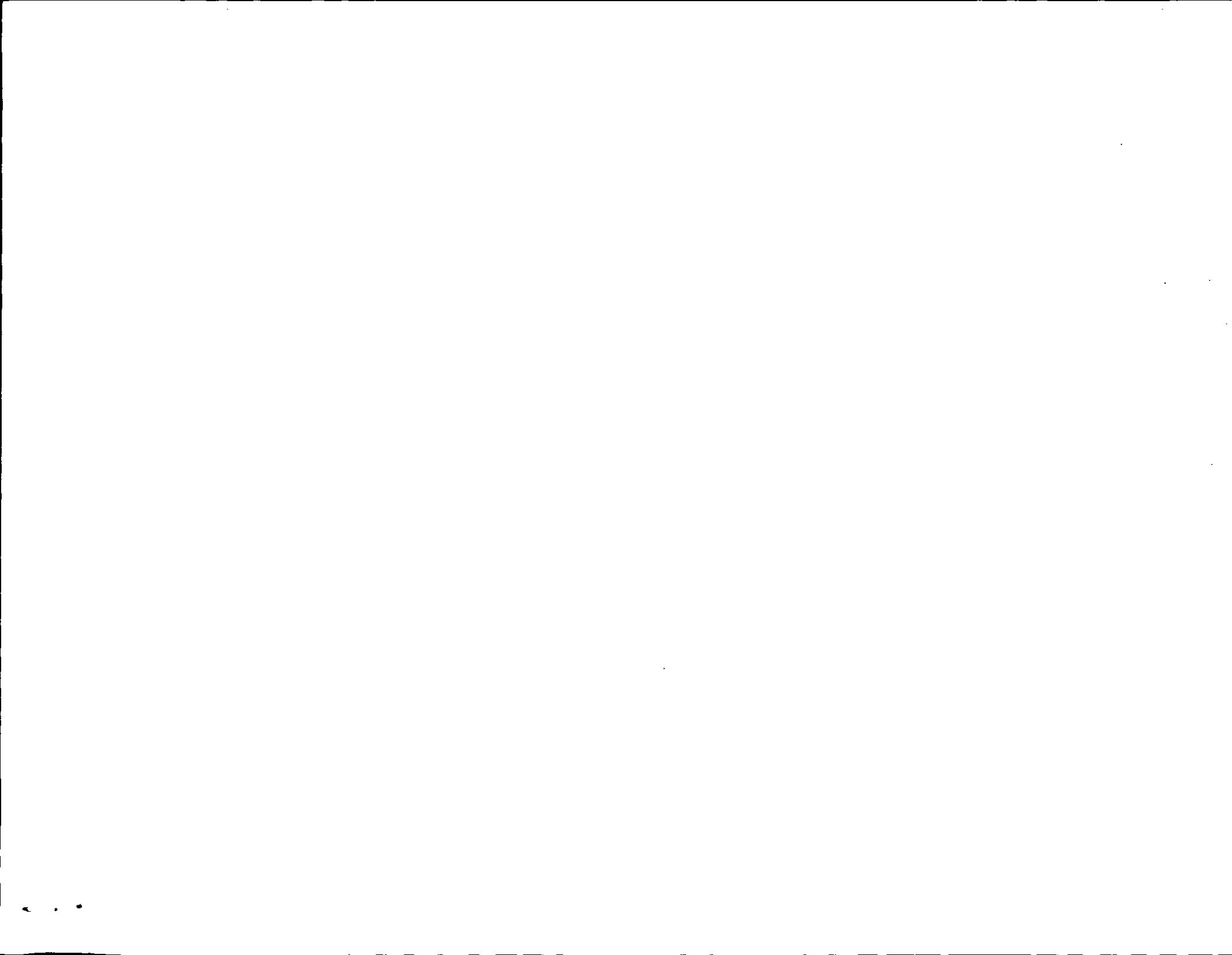
RELEASED  
2010-03-12  
NMP

NOTES:

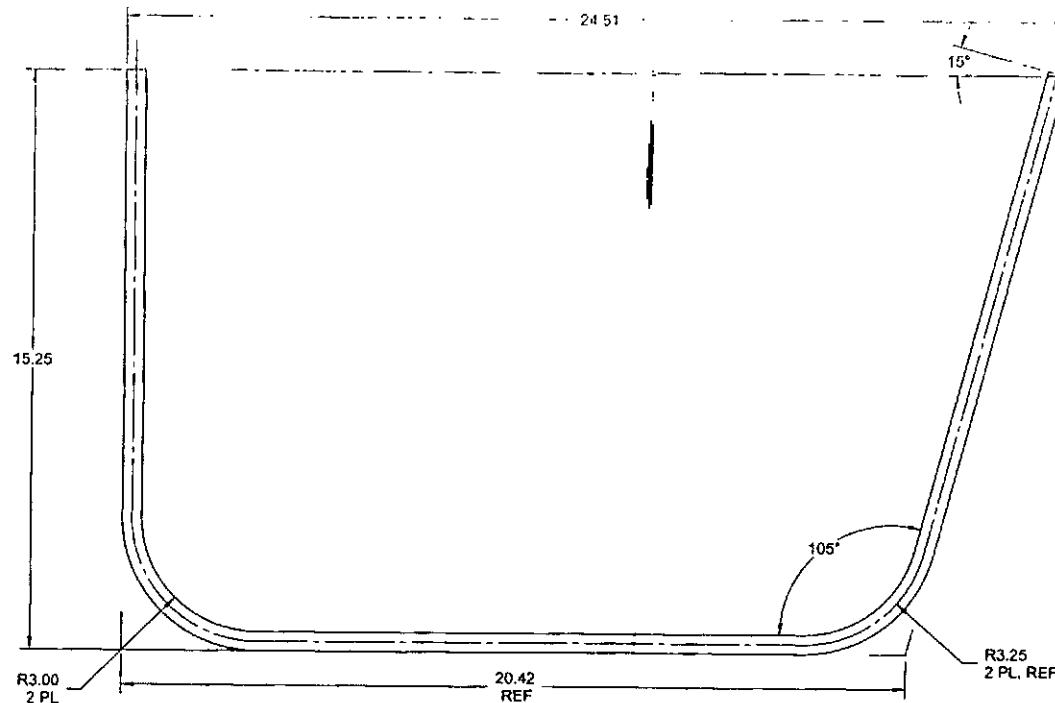
- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SQUARE TUBE, 0.75 X 0.75 X 0.049 WALL  
REF DART SPEC. M304TSU.750W.049
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 1.76 lbs
- 9) TUBE FLAT LENGTH 50.0 REF

8 7 6 5 4 3 2 1

|   |                    |                             |       |  |  |
|---|--------------------|-----------------------------|-------|--|--|
| DESIGN  | AJS                | DART AEROSPACE LTD          |       |  |  |
| DRAWN   | JPH                | HAWKESBURY, ONTARIO, CANADA |       |  |  |
| CHECKED   | <i>[Signature]</i> | DRAWING NO.                 |       |  |  |
| MFG. APPR.  | <i>[Signature]</i> | REV. A                      |       |  |  |
| APPROVED  | <i>[Signature]</i> | D3916                       |       |  |  |
| DE APPR.  | <i>[Signature]</i> | SHEET 3 OF 4                |       |  |  |
| DATE  | 10.03.04           | TITLE                       | SCALE |  |  |
|   |                    | RIB ASSY, 350 BASKET        |       |  |  |
|   |                    | NTS                         |       |  |  |
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100441



⑨ D3916-5 LIGHT RIB

**NOTES:**

- 1) MATERIËL: AISI 304/316 STAINLESS STEEL SQUARE TUBE, 0.50 X 0.50 X 0.049 WALL  
REF DART SPEC. M304TS0.500W.049
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 1.07 lbs
- 9) TUBE FLAT LENGTH 49.5 REF

8 7 6 5 4 3 2 1

|            |           |                             |       |
|------------|-----------|-----------------------------|-------|
| DESIGN     | AJS       | DART AEROSPACE LTD          |       |
| DRAWN      | JPH       | HAWKESBURY, ONTARIO, CANADA |       |
| CHECKED    | <i>E</i>  | DRAWING NO.                 |       |
| MFG. APPR. | <i>E</i>  | REV. A                      |       |
| APPROVED   | <i>JW</i> | D3916                       |       |
| DE APPR.   | <i>AM</i> | SHEET 4 OF 4                |       |
| DATE       | 10.03.04  | TITLE                       | SCALE |
|            |           | RIB ASSY, 350 BASKET        | NTS   |

RELEASED  
2010-03-12  
*JW*

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